



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

(000902)

D5350-043
Job Sheet 169865



Part No: D5350-043

Job Qty: 3 Ea

Part Name: Aft Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/2/18

Job Tracking No:

Due Date: 2/2/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV D SHEET 2 IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP REV:B 16.01.25 rev.a dwg DD
VERF:JLM IPP REV:C 16.06.30 DWG REV.B DD VERF:JLM IPP REV:D 17.01.09 DWG REV.c DD VERF:JLM
IPP REV:E DWG. REV.D 17/04/11 JFS VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	1/31/18	1/31/18	0.00	0.00	Start Up Machining-4		mm
100	Bandsaw	3 pcs	1/31/18	1/31/18	0.00	6.98	Bandsaw1		mm
110	CNC Vertical Machining	3 pcs	2/1/18	2/1/18	0.42	17.65	HAAS1-2		mm
120	QC	3 pcs	2/1/18	2/1/18	0.00	0.00	QC2 Machining-4		mm
130	Mill Conv	3 pcs	2/1/18	2/1/18	0.00	17.33	Mill Conv 1		mm
140	QC	3 pcs	2/1/18	2/1/18	0.00	0.00	QC8		FK 18-2-10
150	Skidtubes	3 pcs	2/1/18	2/1/18	0.00	0.96	Skidtubes-3		BE DAS
160	QC	3 pcs	2/1/18	2/1/18	0.00	0.00	QC5		38
170	HandFinish	3 pcs	2/1/18	2/1/18	0.00	1.03	HandFinish1		18-02-12
180	QC	3 pcs	2/1/18	2/1/18	0.00	0.00	QC7-5		BD 18-2-14
190	Powdercoat	3 pcs	2/1/18	2/1/18	0.00	1.74	Powdercoat1		BD 18-2-14
200	QC	3 pcs	2/1/18	2/1/18	0.00	0.00	QC3		38
210	Small Fab	3 pcs	2/2/18	2/2/18	0.00	1.03	Small Fab-9		38
220	QC	3 pcs	2/2/18	2/2/18	0.00	0.00	QC5		38
230	Packaging	3 pcs	2/2/18	2/2/18	0.00	0.00	Packaging3-2		52605 FEB 20 2018
240	QC21-SA	3 Ea	2/2/18	2/2/18	0.00	0.00	QC21		FEB 20 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X06.000	17	31	0	0
210-Small Fab	CBL-1240	16	142	0	0
	CBL-460	30	154	0	0
	D5346-3	12	19	0	0
	D5350-5	3	7	0	0
	MS17984-C412	6	10	0	0
	MS17984-C418	3	6	0	0
	MS17984-C517	6	52	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S040666

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CANADA
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Aft Beam Assembly

PART NO: D5350 - 043

Original Serial #: S040666

Revision:

Operation:

Change No:

Start up Operation 02/08/18

Job No: 169865

DART AEROSPACE LTD		Work Order: - 169865
Description:		Part Number: 5350-3
Inspection Dwg:	Rev:	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .257	+ .006 / - .001	.258	✓		Pin gage	
0.80	+/- 0.030	.800	✓		high gage	
1.00	+/- 0.030	1.000	✓		high gage	
1.60	+/- 0.030	1.601	✓		high gage	
2.12	+/- 0.030	2.122	✓		high gage	
0.65	+/- 0.030	.652	✓		Vernier	
3.15	+/- 0.030	3.150	✓		Vernier	
33.10	+/- 0.030	33.10	✓		Tape	
35.60	+/- 0.030	35.60	✓		Tape	
0.55	+/- 0.030	.550	✓		Vernier	
.240	+ 0.015 / - 0.005	.277	✓		high gage + Pin	
12.000	+/- 0.005	11.998	✓		Vernier	
0.62	+/- 0.030	.615	✓		Vernier	
5.42	+/- 0.030	5.405	✓		high gage	
4.25	+/- 0.030	4.236	✓		high gage	
0.30	+/- 0.030	.298	✓		Vernier	
0.35	+/- 0.030	.347	✓		Vernier	
2.50	+/- 0.030	2.500	✓		Vernier	
0.70	+/- 0.020	.700	✓		Vernier	
1.50	+/- 0.030	1.501	✓		Vernier	
1.00	+/- 0.030	1.003	✓		Vernier	
0.550	+/- 0.010	.559	✓		Vernier	
0.225	+/- 0.010	.222	✓		Vernier	
0.045 x 45°	+/- 0.015 +/- 0.5°	.060	✓		Vernier	
2.05	+ 0.030 / - 0.015	2.049	✓		high gage	
1.030	+ 0.015 / - 0.00	1.030	✓		Vernier	
0.250	+ 0.015 / - 0.010	.250	✓		Vernier	
0.480	+/- 0.015					
Ø .375	+ 0.000 / 0.001	.374	✓		Pin gage	
0.415 x 90°	+/- 0.010 +/- 0.5°					
3.84	+/- 0.030	3.874	✓		Vernier	
0.30	+/- 0.030	.300	✓		Vernier	

Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:		Date:	18-2-10	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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B	14.07.31	New Issue	KJ	



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Master Unit 000902

Tel (613) 632-5200

Containers on Master Unit 000902				
Serial No	Part No	Customer Part No	Status	Quantity
S042509	D5346-3		Allocated	8
S042508	D5350-5		Allocated	2
S042505	MS17984-C412		Allocated	4
S042506	MS17984-C418		Allocated	2